

Wednesday, 1/23/2008 11:39:00 AM

Kim Johnston

Process Sheet

Job Number	: CU-DAR001 Dart Helicopters Services			Drawing Name	: DDOUBLER		
Estimate Number	: 36928			Part Number	: D2911		
P.O. Number	: 11592			Drawing Number	: D2911 REV A		
This Issue	: 1/23/2008 S.O. No. :			Project Number	: N/A		
Prsht Rev.	: NC			Drawing Revision	: A		
First Issue	: / / Type : SMALL /MED FAB			Material	:		
Previous Run	: 31828			Due Date	: 1/30/2008 Qty: 40 Um: Each		
Written By	: <u>BJ 080123</u>						
Checked & Approved By							
Comment	: Est B 02.11.12 Re-format; Incorporated D2911 and D2912 K						
	J						
	Est Rev:C Now on Waterjet 07-01-23 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S090	6061-T6 .090 Sheet
Comment: Qty.: 0.1219 sf(s)/Unit Total : 4.8762 sf(s) 6061-T6 .090 Sheet Material: Sheet 6061-T6 x 0.090" thick (M6061T6S.090) Batch: <u>19059</u> <u>19059</u> <u>EB 8-1-28</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2911 Dwg Rev: <u>A</u> <u>EB 8-1-28</u> Prog Rev: <u>A</u>		
2-Deburr if necessary <u>EB 8-1-28</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>EB 8-1-28</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
<u>EB 8-1-28</u> <u>coatings</u> <u>EB 8-1-28</u> <u>X54</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:39:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DDOUBLER

Job Number: 36928

Part Number: D2911

Job Number:



Seq. #: Machine Or Operation:

Description:

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form on CNC brake as per Dwg D2910, D2911, D2912 and QSI 034 4.1

88

08/01/07

54

6.0 CHEMICAL TREAT CHEMICAL TREATMENT



Comment: CHEMICAL TREATMENT

M-1

08/02/07

54X

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

✓ 08/02/07 X54 counts

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST53

AS 08/02/07 X54

54

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/08

Job Completion



min 2008/2/07

✓

54

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36928
Description: Doubler	Part Number:	D2911
Inspection Dwg: D2911	Rev: A	Page 1 of 1

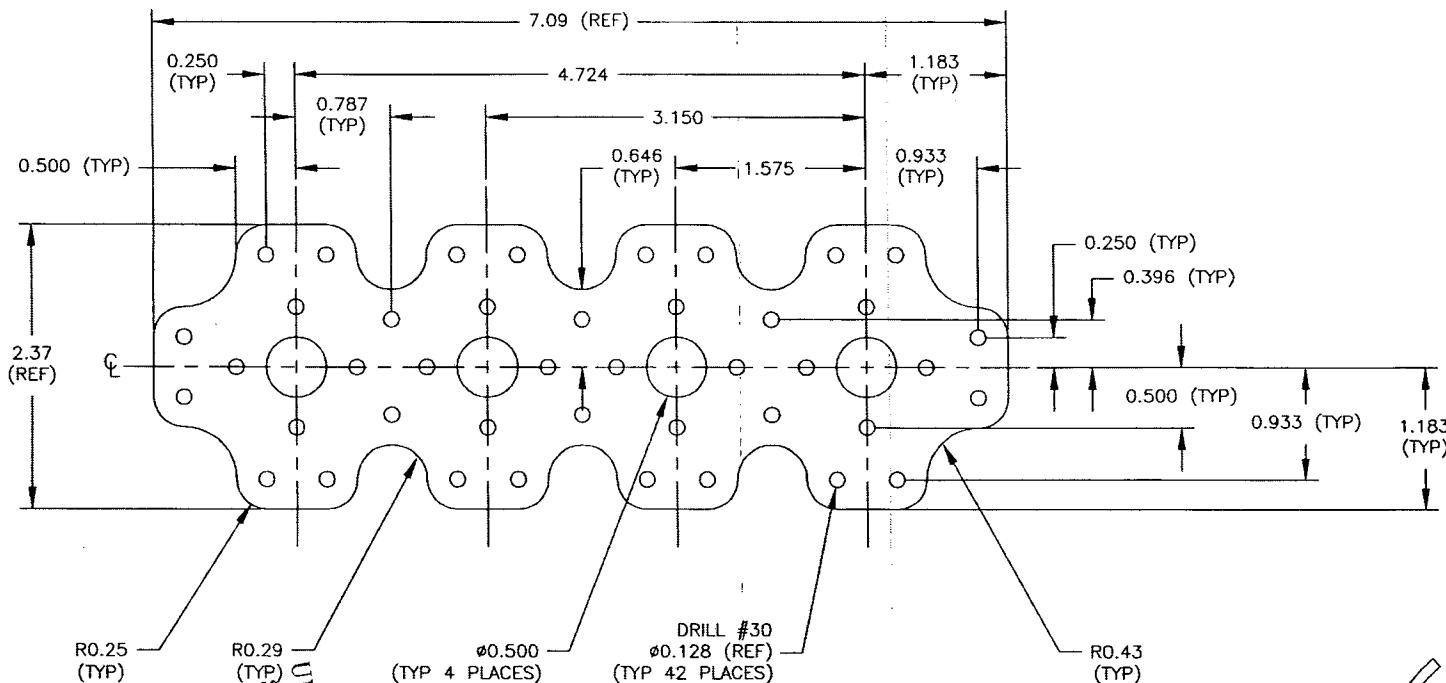
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>FB</u>	Audited by: <u>J</u>	Prototype Approval: N/A
Date: <u>8-1-28</u>	Date: <u>08/01/28</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

RELEASED
49-09-28 09



MATERIAL: 6061-T6 SHEET (QQ-A-250/11) 0.091" THICK
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES

A		99.09.08	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CP	RF	CHECKED	APPROVED
CP	RF	DRAWING NO.	REV. A
		D2911	SHEET 1 OF 1
DATE	SCALE	TITLE	1:1
99.09.08		DOUBLER	